

# Work Order ID 72249

Wednesday, July 20, 2011 9:53:50 AM



Page 1

Item ID: D4055-11

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Front and Bottom

Start Date: 7/20/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 8/3/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 11-07-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr	Revision Nbr
D4055	B

100

0.00



Purchasing

Memo

0.00

Purchasing

Issue P/O: 14532  
Purchase part as per Dwg D4055  
Possible Supplier: GFI  
Material release note required

CL 11/07/20 (4)

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

CL 11/08/13 (4)

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Sub 6/13

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4X Ø M-11/08/22

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 Ø 11/08/22

150

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

4 Ø 11-09-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 72249**

Wednesday, July 20, 2011 9:53:50 AM



Page 3

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Start Date: 7/20/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 8/3/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/12

MF  
11-09-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, July 20, 2011 9:53:47 AM

Page 1

Work Order ID: 72249



Parent Item: D4055-11



Parent Item Name: Tank Front and Bottom


Start Date: 7/20/2011

Required Date: 8/3/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4055-11P  Tank Front and Bottom		Purchased	No			110	Each	0.0000	1	4			



CEL 11/08/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





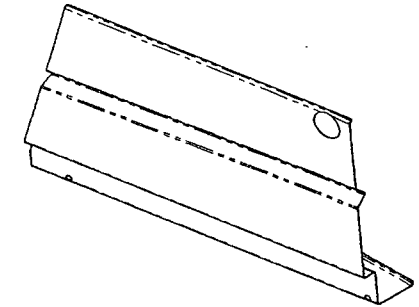
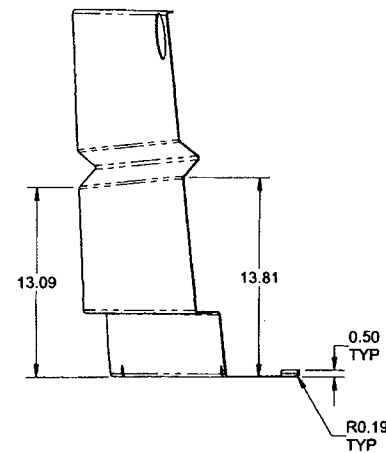
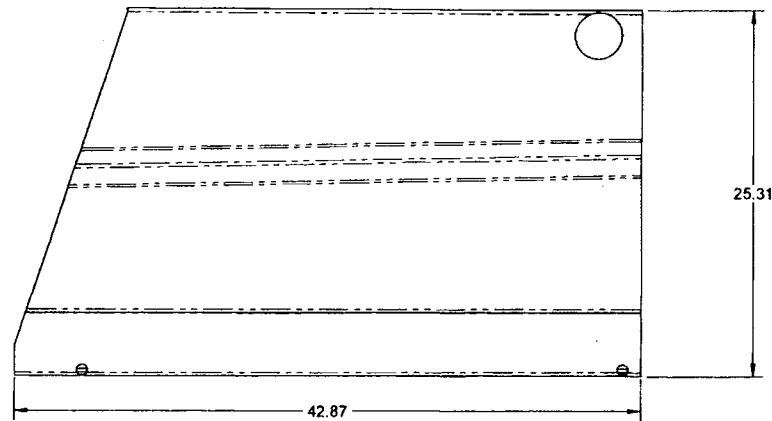
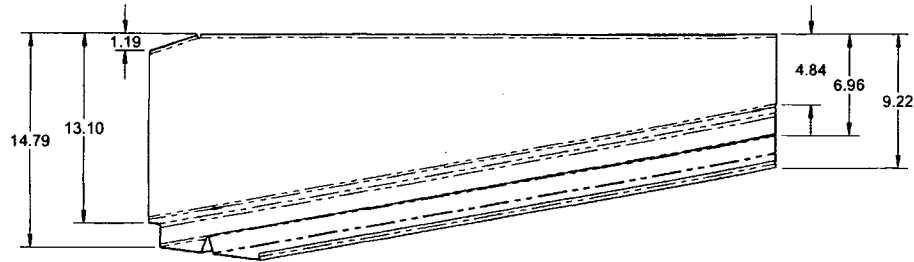
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4055-11 TANK FRONT AND BOTTOM**

**NOTES:**

- 1) MATERIAL: MADE FROM D4055-11F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.32 lbs



DESIGN	<i>AB</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>AB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AB</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>AB</i>	D4055	SHEET 14 OF 15
APPROVED	<i>AB</i>	TITLE	SCALE
DE APPR.	<i>AB</i>	TANK	NTS
DATE	11.05.12	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

**RELEASED**  
2011-05-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



180 AVENUE LABROSSE  
POINTE-CLAIRE, QC, CANADA H9R 1A1  
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



# BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON / SHIPPING MEMO NO.		PAGE
JR - DY	MO - MO	AN - YR			
12	08	11	0467698		1/1



EXPÉDIE À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON  
K6A 1K7

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON  
K6A 1K7

CODE DE CLIENT / CUSTOMER CODE		N° DE CONTRAT / JOB NO.	VOTRE N° DE COMMANDE / YOUR PURCHASE ORDER NO.	EXPÉDIÉ PAR / SHIP VIA				
DART		GFI-0299	0234765	PO14532				
QUANTITÉ / QUANTITY	N° DE PIÈCE / PART NO.		DESCRIPTION					
4	D4055-11P ✓		TANK FRONT AND BOTTOM					
	CXL1108117		ITEM 3					
			C OF C REQ'D					
MFG. JOB# J0234765 - 001 QTY 4 pcs								
EXPÉDITEUR / SHIPPER				N° DE BON DE LIVRAISON / SHIPPING MEMO NO.				



REÇU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.  
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

CERTIFICATE OF COMPLIANCE  
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	<u>6</u>	OUR JOB NO	<u>J0234765</u>	SHIPPING MEMO	<u>0467698</u>	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
--	<u>4 PCS</u>	<u>PO14532</u>	<u>D4055-11P</u>	<u>B</u>	<u>TANK FRONT AND BOTTOM</u>	<u>B</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
<u>.063 THK AL 6061-T6</u> <u>(AMS-QQ-A250/11)</u>		<u>SAMUEL / ALCOA INC</u>		<u>613714</u>		
PROCESS		PROCESSOR		RELEASE NOTE #		
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>		<u>GFI</u>	<u>N/A</u>		
2	<u>REF. GFI MANUFACTURING JOB NUMBER J0234765-001 (4 PCS)</u>					
3						
4						
5						
6						
7						
8						
9						

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 12 AUGUST 2011

G.F.I. Q.C. REP.

*Antoine Herd*

**LES MÉTAUX  
SPÉCIALISÉS  
SAMUEL**

Programme d'Assurance Qualité Enregistré / Registered Q.A. Program  
ISO 9001:2008 + AS9100B

**LETTRE DE CONFORMITÉ - LETTER OF COMPLIANCE**

**Date:** August 12, 2011

**Company Name:** GFI Division of Thomas & Betts limited  
**Address:** 180 avenue Labrosse  
**City:** Pointe-Claire Qc  
**Zip Code:** H9R 1A1

**# du client:** 78920

**Customer's order #:**

**# de commande SSMQ:** 552438

**SSMQ's Order #:**

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
01	3	.0630" X 48" X 144"	6061 T6	AMS-QQ-A-250/11	613714

Bien à vous,  
Yours truly,



# CERTIFIED INSPECTION REPORT

Alcoa Inc.

DAVENPORT WORKS 4079 State Street Bettendorf, IA 52722

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

This last report shall not be reproduced except in full, without the written approval of the Quality Department. No alteration, addition or other change is authorized to be made to this certificate. The recording of false, fictitious, or otherwise fraudulent statements or entries on this certificate by any recipient may be punished as a felony under applicable law.

Malcolm Murphy  
Director of Manufacturing Davenport Works

Terrence Thom  
Quality Assurance Manager

1263222  
Ship Date 2011-07-01  
B.L. No. 6040526  
Invoice No. 00000  
Alcoa No. Item 1000291425-1  
P.O. No./Govt Contract No. C63748 Ln#: 1  
Customer SAMUEL SON & CO LT  
Alcoa Item G041094947R05  
DCE-91425-1

Page 1 of 2

Ship To: SAMUEL SON & CO LTD  
S.S.M.Q  
21525 CLARKE-GRAHAM  
BAIE D'URFE H9X 3T5 QC

Item Description  
0.063 IN TK (+0.0000 -.0035) X 48.0 IN W (+.125 -.125) X 144.0 IN LN (+.15625 -.15625) (N) A/T 6061-T6 FLAT SHEET FOR DISTRIBUTORS TOLERANCE  
GUARANTEED. AMS4027 REV N EKC MRK  
ASTMB209 REV 07 CMP025 REV S ((MARKED))  
KRAFT PAPER INTERLEAVED  
MAX GROSS SKID WGT: 4500 LB QUAN TOL +/- 30 % CQR 0210640 REV 05 CUST REQ 11-06-11 \*\*\* W/E 11-06-18 \*\*\*

Suloxide

Num	Package Ticket	Lot	Weight	Quantity	UOM	Inspector Clock Numbers
1	315871	613714	2326	57	PC	27107 27707 47004

Notes for CQR: 0210640.5  
PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS4027 REV N ALSO MEET THE REQUIREMENTS OF AMS-QQ-A-250\_11 ORIGINAL REVISIO N DATED 1997-08-01.

CQR: 0210640.5 -Specification Limits

Temp	Dir	UTS	TYS	EL4D
T6	Long Transv.	KSI	KSI	PCT
	Max			
	Min	42.0	35.0	10

## Chemical Composition

	SI	FE	CU	MN	MG	CR	ZN	TI	Other	Other
Alloy 6061	Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05
Lot: 613714	Min	0.40		0.15		0.8	0.04			0.15

- Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No->	UTS	TYS	EL4D
T6	Long Transv.	Test	KSI	KSI	PCT
		2	50.2	44.6	10.5
			51.1	45.6	10.3

REMAIN



# CERTIFIED INSPECTION REPORT

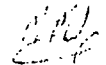
Alcoa Inc.

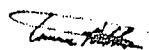
DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

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Per:   
Malcolm Murphy  
Director of Manufacturing Davenport Works

  
Terence Thom  
Quality Assurance Manager

1263222	0		
Ship Date	B.L. No.	Invoice No.	Alcoa No. Item
2011-07-01	6040526	00000	1000291425-1
P.O. No./Govt Contract No.	Customer	Alcoa Item	
C63748 Ln#: 1	SAMUEL SON & CO LT G041094947R05		

Page 2 of 2

Lot: 613714 - Mechanical, Physical, Metallography, Quantometer Results (cont.) -----  
Cast Number Chemical - OES SI FE CU MN MG CR ZN TI  
H9334105 Actuals 0.65 0.4 0.25 0.07 1.0 0.16 0.06 0.03

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States